

Date: Monday, 6/5/2006 7:38:18 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY		
Job Number	: 27340C		Part Number	: D41269403		
Estimate Number	: 12353		Drawing Number	: D412-694		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/5/2006	S.O. No. : N/A	Drawing Revision	: C1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/15/2006 Qty: 1 Um: Each		
Previous Run	: 27323C					
Written By						
Checked & Approved By						
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY 

## Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-03. CHG005

## Comment: COMPOSITE ASSEMBLY

D412-694-03 Drill Process

1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference.

✓ 2- Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3.

✓ 3- Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3113-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM).

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.).

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF).

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom.

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
07/10/11	2	The jig DT 3144-T4 do not exist Use draw for making holes.	mf	07/10/11		07-10-15	04-10-15

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #: Machine Or Operation:

Description :

3.0 QC5

INSPECT WORK TO CURRENT STEP



Removed - 07/10/15



N/A initial/n/a

Comment: INSPECT WORK TO CURRENT STEP

4.0 8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

M15893

M104835

Expiry Date:

17 May 2008

✓ ml

5.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

ml 07/10/15

6.0 QC5

INSPECT WORK TO CURRENT STEP



07-10-15



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

SP 07-10-16

8.0 QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

SP 07/10/16

9.0 D31101

Handle

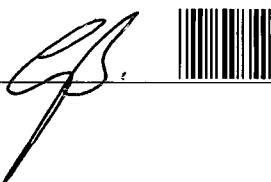


Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B24673



10.0 D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B27539



SP 07/09/180

W/O:		WORK ORDER CHANGES							
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Machine Or Operation:

Description :

11.0 D3111041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Plate Assembly

Batch

M10536-17

12.0 D311121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

B 35234

13.0 D311131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring

Batch

B 27366

14.0 D311141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pivot

Batch

B 18630

15.0 D311165

Seal 110-031-4



Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)

Seal 110-031-4

Batch

B 27208

16.0 D3111611

SEAL



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)

SEAL

Batch

B 24675

17.0 D31119041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch

B 27724

W/O:		WORK ORDER CHANGES							
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Seq. #: Machine Or Operation:

Description :

18.0 D31201 Cover, Flat Pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover, Flat Pattern

Batch

19.0 D31203 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

20.0 D31251 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

21.0 D31253 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

22.0 D31255 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

23.0 D31257 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

24.0 D31291 Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever

Batch

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Job Number:



Seq. #: Machine Or Operation:

Description :

25.0 D31301 Clevis Base



*JP.*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis Base

Batch

M10536-17-

26.0 D31311 Stop



*JP.*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Stop

Batch

M10536-17-

27.0 D31341 Rod



*JP.*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod

Batch

B27338-

28.0 D31343 Rod



*JP.*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod

Batch

A10536-17 B24682

*✓ ml*

29.0 D314007 Door Kit



*JP.*



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Door Kit

Batch

B27340C

*ml*

30.0 D31431 Clevis



*JP.*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Batch

M10536-17-

31.0 D31433 Clevis



*JP.*



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clevis

Batch

B18816-

*JP. 07/09/180*

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 D31441 Doubler



*JP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler  
Batch

B18816

33.0 D3144105 Doubler



*JP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler  
Batch

B23143

34.0 D3144107 Doubler



*JP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler  
Batch

D23144

35.0 D31451 Bracket



*JP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket  
Batch

B26502

36.0 D31461 Hinge Bracket



*JP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket  
Batch

D26709

37.0 D31471 Pin



*JP*



*ml ✓*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin  
Batch

B30824

38.0 D31491 Striker Plate



*JP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate  
Batch

M10536-17

*EDoA/09/18*



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Job Number:



Seq. #: Machine Or Operation:

Description :

39.0 D31501 Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

M10536-17

40.0 D31541 Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

P1053617

JP.

41.0 D31571 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M10536-17

JP.

42.0 D3159041 Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

D18641

JP.

43.0 D3159043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

b24707

JP.

44.0 AN52510R7 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M1041214

JP.

45.0 AN960JD6L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M15519

JP.

JP. 07/09/180

W/O:		WORK ORDER CHANGES							
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Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #: Machine Or Operation:

Description :

46.0 AN960JD8 Washer



*JP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

~~Washer~~  
Batch

*M104374*

47.0 AN960JD8L Washer



*JP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer  
Batch

*M16956 -*

48.0 AN960JD10 Washer



*JP*



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

~~Washer~~  
Batch

*M104885*

49.0 AN960JD10L Washer



*JP*



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer  
Batch

*M1103044 -*

50.0 AN960JD10LL Washer



*JP*



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer  
Batch

*M19600 -*

51.0 ALS463280 Insert



*JP*



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert  
Batch

*M17841 -*

52.0 BSP45 Commercial Rivet



*JP*



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet  
Batch

*M11821 -*

*JP 07/09/18*

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

53.0 BSP46 Commercial rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Commercial rivet

Batch

M107098-

*[Signature]*

54.0 FW4032 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M11822-

*[Signature]*

55.0 FW10032 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

M101203-

*[Signature]*

56.0 M7885344 Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivets

Batch

M15659

*[Signature]*

57.0 M7885345 Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rivet

Batch

M1108-

*[Signature]*

58.0 MS203921C11 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18822-

*[Signature]*

59.0 MS203922C11 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M14149-

*[Signature]*

*[Signature]*  
P0709/80

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

60.0 MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

M11796

61.0 MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

M104936

62.0 MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M104603

63.0 MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

M14526

64.0 MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15924

65.0 MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15798

66.0 MS24694S56

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

M104407

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

67.0 MS24694S60 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M104407-

68.0 MS25281R6 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

M19098-

69.0 MS27039106 Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M11754-

70.0 MS27039108 Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M104215-

71.0 MS35206231 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M11735-

72.0 MS35650305T Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M11786-

73.0 MS518597 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M11822-

W/O:		WORK ORDER CHANGES							
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Seq. #: Machine Or Operation:

Description :

74.0 NAS116910L Washer



*JP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

*M11753 -*

75.0 NAS38868P Screw



*JP*



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

*M19098 -*

76.0 NAS39186P Washer



*JP*



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Washer

Batch

*M19098 -*

77.0 NAS43DD340 Spacer



*JP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

*M11737 -*

*JP 07/09/00*

78.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-03 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB). Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:38:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

9- Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.

Note: Position strike plate when big door is in locked position.

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3.

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

17- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

ml 07/10/22

79.0

QC5

INSPECT WORK TO CURRENT STEP

79.A



7/10/23

Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

79.B. Put Red Label inside before the cover D3119-041 / OR VIP TRIM ) ml 07/10/23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				
07/10/23	79	Have to replace Seal D 3116-5-0680 Seal was torn.	QSIU12	Took out one D 3116-5-0680 x1 Took out BSP45- x47 SC VAP QTY 7 Replace them by new D 3116-5-0680 x1 <u>823699</u> BSP45 x 47 <u>M11 821</u>	ml 07/10/23	07-10-23	QSIU12	07-10-23	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/24

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:38:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #: Machine Or Operation:

Description :

80.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

C207110124

(1)

81.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Dor10105

Job Completion



u St-024

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

RELEASED

05-10-04

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
X				D412-694-02	DOOR ASSEMBLY
X				D412-694-03	DOOR ASSEMBLY
X				D412-694-04	DOOR ASSEMBLY
1	1			D3101-1	SCOUTHEON
1	1			D3103	HANDLE
1	1			D3105	HANDLE ASSEMBLY
1	1			D3111-041	PLATE ASSEMBLY
2	2			D3112-1	GUIDE
				D3113-1	SPRING
				D3114-1	PIVOT
1	1			D3115-1	BRACKET
				D3116-11-010	SEAL
				D3116-5-060	SEAL
1	1			D3116-7-060	SEAL
1	1			D3116-8-070	SEAL
				D3119-041	COVER ASSEMBLY
				D3119-042	COVER ASSEMBLY
	1			D3120-1	COVER
	1			D3120-2	COVER
	1			D3120-3	COVER
	1			D3120-4	COVER
3	3			D3124-041	BRACKET ASSEMBLY (ROLLER)
1				D3124-043	BRACKET ASSEMBLY (ROLLER)
1				D3124-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
	1	1		D3125-1	LEVER
	1	1		D3125-3	LEVER
	1	1		D3125-5	LEVER
	1	1		D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
				D3128-1	SHIM
	2	2		D3129-1	LEVER
	2	2		D3130-1	CLEMS BASE
	1	1		D3131-1	STOP
1				D3132-04	ROD WELDMENT
1				D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
	1	1		D3134-1	ROD
	1	1		D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
				D3138-1	COVER
				D3138-2	COVER
1	1			D3139-1	GUARD
1				D3139-3	GUARD
1				D3139-4	GUARD
1				D3140-05	DOOR
1				D3140-05	DOOR
	1			D3140-07	DOOR
	1			D3140-08	DOOR
2	2			D3141-1	SPRING
	1	1		D3143-1	CLEMS
3	3			D3143-3	CLEMS
1				D3144-1	DOUBLER
				D3144-3	DOUBLER
1				D3144-105	DOUBLER
1				D3144-107	DOUBLER
				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
	1			D3144-117	DOUBLER
	1			D3144-121	DOUBLER
	1			D3144-119	DOUBLER
	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
	1			D3145-1	HINGE BRACKET
	1			D3145-2	HINGE BRACKET
	1			D3145-1	HINGE BRACKET
	1			D3145-2	HINGE BRACKET
	2	2		D3147-1	PIN
2	2			D3148-1	CLEMS
	2	2		D3149-1	STRIKER PLATE
	2	2		D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
	1			D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3155-1	BRACKET
	2	2		D3157-1	SPACER
3	3			D3159-041	BRACKET ASSEMBLY
	1			D3159-043	BRACKET ASSEMBLY
	1			D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1	1			D3162-043	BRACKET ASSEMBLY
1	1			D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
1				D3163-042	COVER ASSEMBLY
1				D3163-041	BRACKET ASSEMBLY (ROLLER)
1				D3163-042	BRACKET ASSEMBLY (ROLLER)
	1			D3203-1	HANDLE ASSEMBLY
2	2			D3208-1	DOUBLER
55	55	21	21	80-005-28	INSERT FOR SL2062-3-4
10	10			AN25-106	SCREW
8	8	4	4	AN25-107	SCREW
	8	8		AN260UD10	WASHER
18	18	4	4	AN260UD10L	WASHER
13	13	32	32	AN260UD10L	WASHER
6	6			AN260UD16L	WASHER
6	6			AN260UD16L	WASHER
	2	2		AN260UD16L	WASHER
	2	2		AN260UD16L	WASHER
10	10			AS4-452-80	INSERT
87	87	50	50	BS495	RIVET
	12	12		FM10-032	WASHER
6	6			FM4-032	WASHER
12	12			M7265-24	RIVET (OR DR3214-3)
	3	3		M7265-34	RIVET (OR DR3214-3)
	2	2		MS20392-1C11	PIN
	7	7		MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD4	RIVET
12	12			M7285-3/4	RIVET
8	5			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
	6	6		MS21042105	NUT
6	6	2	2	MS21042105	NUT
	5	5		MS2104213	NUT
4	4			MS210424	NUT
4	4			MS21072-L3	NUTPLATE
6	6	9	9	MS2465-151	COTTER PIN
4	4			MS2469-4	SCREW
4	4			MS2469-5	SCREW
6	6			MS2469-55	SCREW
18	18			MS2469-550	SCREW
	4	4		MS2469-555	SCREW
	2	2		MS2469-555	SCREW
	4	4		MS2469-555	SCREW
	4	4		MS25281-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-05	SCREW
13	13	6	6	MS27039-1-08	SCREW
	2	2		MS3203-231	SCREW
	2	2		MS35275-233	SCREW
	4	4		MS3565-305T	NUT
	2	2		MS3663-325	NUT
	2	2	3	MS3169-7	WASHER
	4	4		NAST165-10L	WASHER
	14	14		NAS388-6P	SCREW
	15	15		NAS3161BP	WASHER
7	7			NAS4003-10	SPACER
6	6			NAS4003-14	SPACER
	2	2		NAS4003-40	SPACER

#### GENERAL NOTES

- 1 FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW.
- 2 IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEMS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- 3 HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. B30-2300-01; D6144-T1/T2-T3; D78703-3; D3162-04111 (FOR -01 DOOR ASSY); B30-2300-04; D3144-T7-T8-T9; D78703-4; D3162-04112 (FOR -02 DOOR ASSY); D3144-T4/T5-T6; D319-04111; D3112-T4-T2 (FOR -03 DOOR ASSY); D3144-T10-T11-T12; D3119-04271; D3112-T4-T2 (FOR -04 DOOR ASSY).
- 4 INSTALL INSERTS PER DART QSI 018. LOCATE TO MATCH HOLE PATTERN OF NATING PARTS.
- 5 TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
- 6 ALL DIMENSIONS ARE IN INCHES
- 7 IDENTIFY D412-694-01-04/04-04 DOOR ASSEMBLIES USING D2729-1 DECALS

C1 06.03.28 ADD OPTION M7885/3-4

C 05.11.23 ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES

B 04.10.07 UPDATE DRAWING

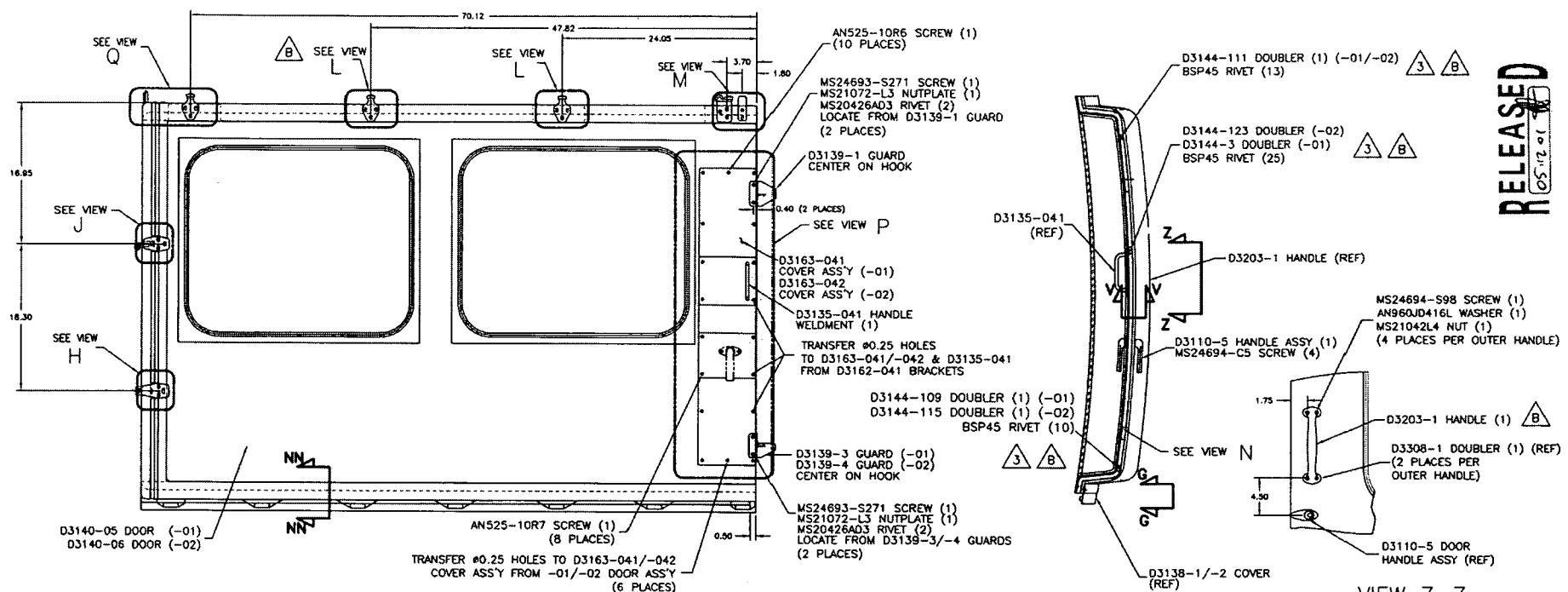
A C2.05.21 NEW ISSUE

DESIGN CP	DRAWN BY RF	<b>DART</b>		DART AEROSPACE LTD. MARKSBURY, ONTARIO, CANADA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>			REV. C
				D412-694
DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS

NO. 21340C  
WORK ORDER COPY  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

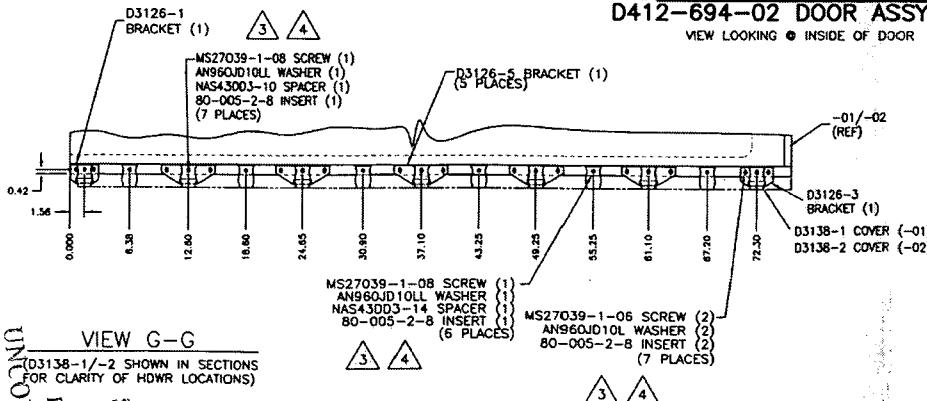
RETURN TO  
D412-694-01-04/04-04

RELEASED  
05-12-01



### D412-694-01 DOOR ASSY (SHOWN) D412-694-02 DOOR ASSY (OPP.)

VIEW LOOKING @ INSIDE OF DOOR



VIEW G-G  
(D3138-1/-2 SHOWN IN SECTIONS FOR CLARITY OF HDWR LOCATIONS)

NO 27305 C  
WORK ORDER  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

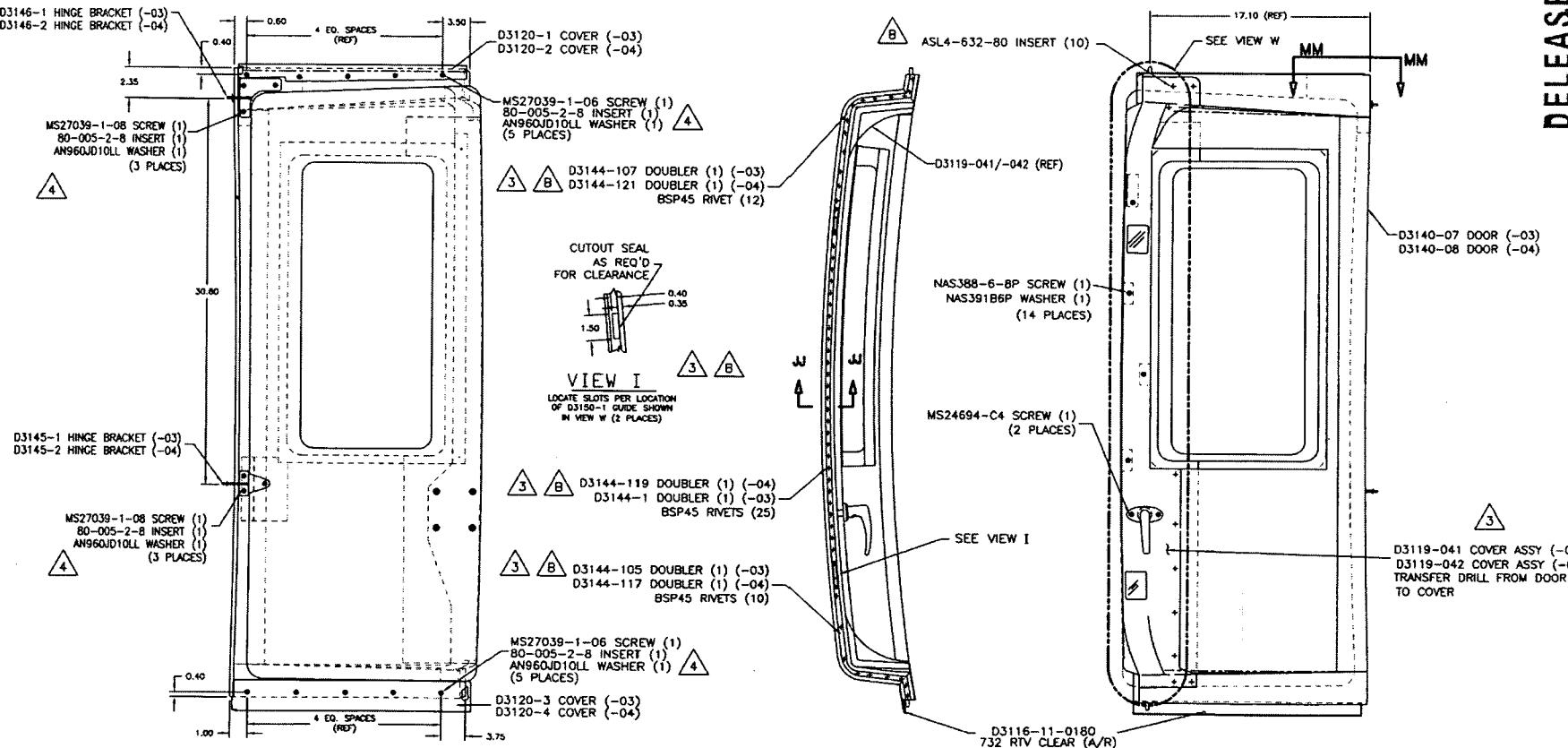
DESIGN CP	DRAWN BY RF	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D412-694
DATE			TITLE DOOR ASSEMBLY

REV. C

SHEET 2 OF 6

NTS

**RELEASED**



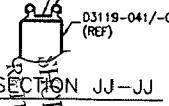
D412-694-03 DOOR ASSY (SHOWN)  
D412-694-04 DOOR ASSY (OPP)

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN CP	DRAWN BY RF	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>		REV. C
DATE 05.11.23		DRAWING NO. D412-694	SHEET 3 OF 6
		TITLE DOOR ASSEMBLY	SCALE NTS

D3116-5-0680  
SEAL (A/R)

D3119-041/-042  
(REF)



SECTION JJ-JJ

SECTION P COPY

SECTION T COPY

SECTION U COPY

SECTION V COPY

SECTION W COPY

SECTION X COPY

SECTION Y COPY

SECTION Z COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

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SECTION YY COPY

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SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

SECTION YY COPY

SECTION ZZ COPY

SECTION AA COPY

SECTION BB COPY

SECTION CC COPY

SECTION DD COPY

SECTION EE COPY

SECTION FF COPY

SECTION GG COPY

SECTION HH COPY

SECTION II COPY

SECTION III COPY

SECTION IV COPY

SECTION VV COPY

SECTION WW COPY

SECTION XX COPY

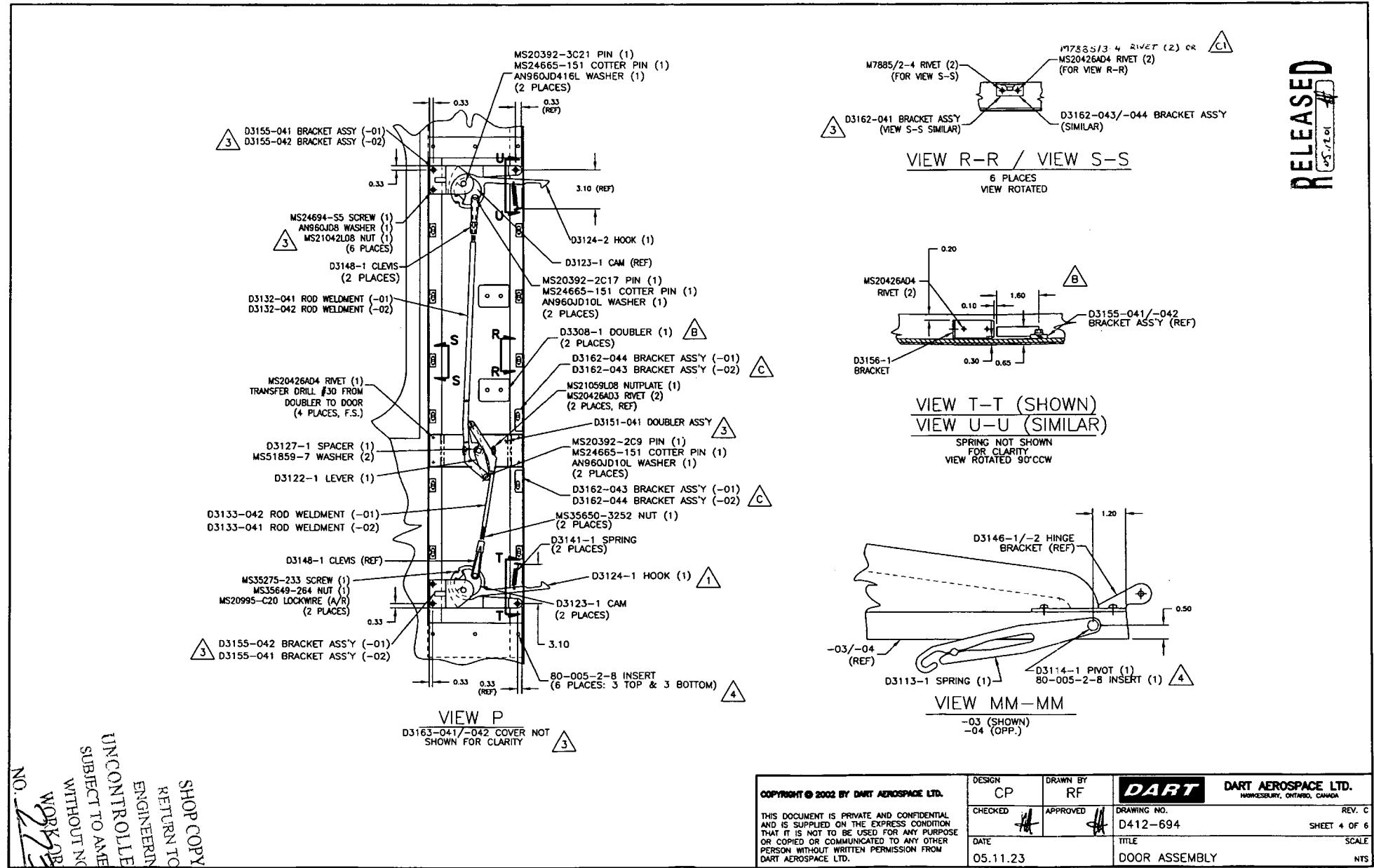
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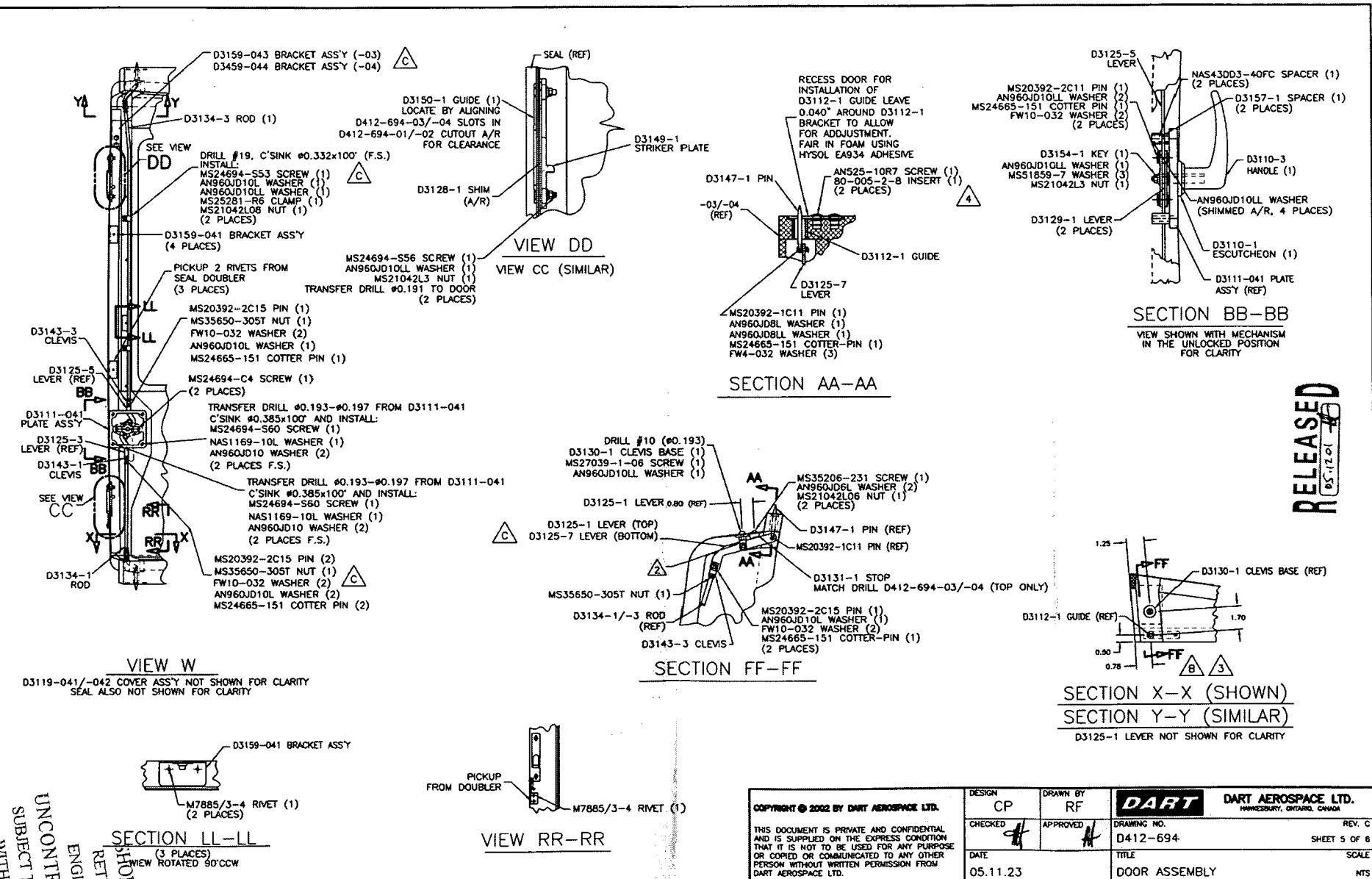
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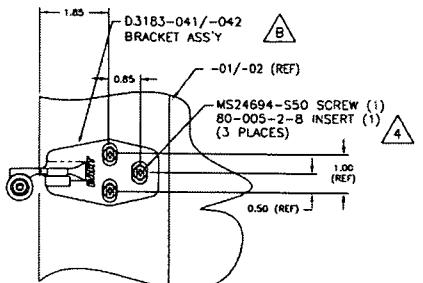
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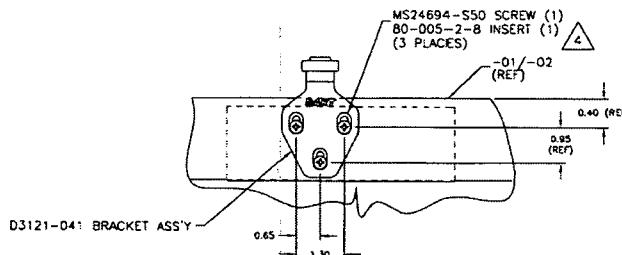
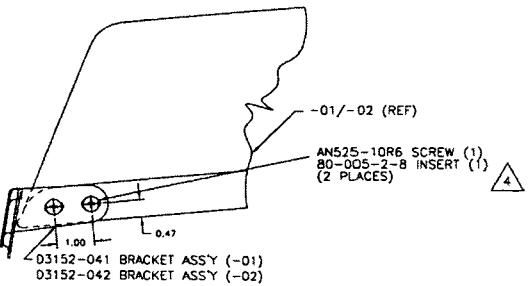
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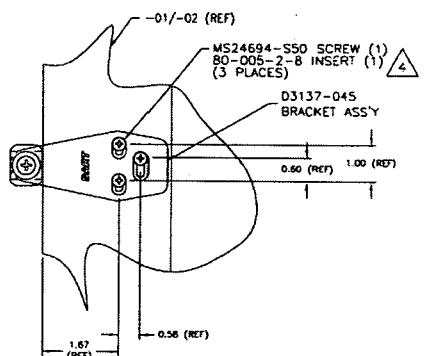


VIEW J

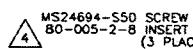
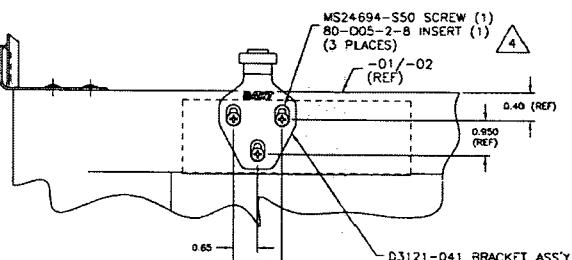


VIEW L

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VIEW Q



VIEW M

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